

Date: Tuesday, 4/17/2007 3:56:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WASHER
Job Number	: 31933		
Estimate Number	: 11314		
P.O. Number	: <u>NIA</u>	Part Number	: D34571
This Issue	: 4/17/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D3457 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: <u>NIA</u>	Material	: <u>NIA</u>
Written By	: <u>[Signature]</u>	Due Date	: 5/10/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	10 Um: Each
Comment	: Est. A 05.10.03 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0218 f(s)/Unit Total : 0.2184 f(s)
 Delrin Round Bar 1"
 Material: Delrin Round Bar Ø1.000
 (M-DELRIN-R1.000)
 Batch: 17104346
 Identify for D3457-1

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA589 Rev: A & Dwg D3457 Rev: A

MS 07/06/13 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment:

Machine as per Folio FA589 Rev: AA & Dwg D3457 Rev: A

J-F. 07/06/17 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 07/06/17 (10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SN 07.06.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:54 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 31933

Part Number: D34571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

J.F. 07/06/17 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 105

Pu 7/6/18 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD 7/06/18 (10)

Job Completion



u 07.06.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

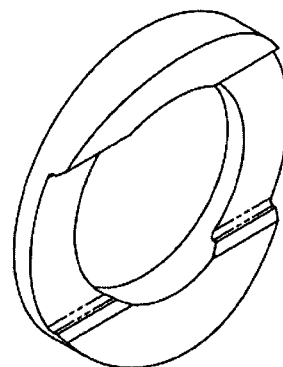
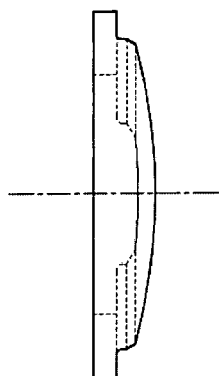
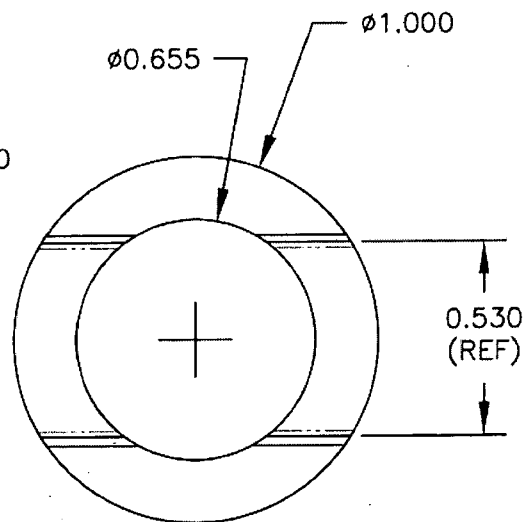
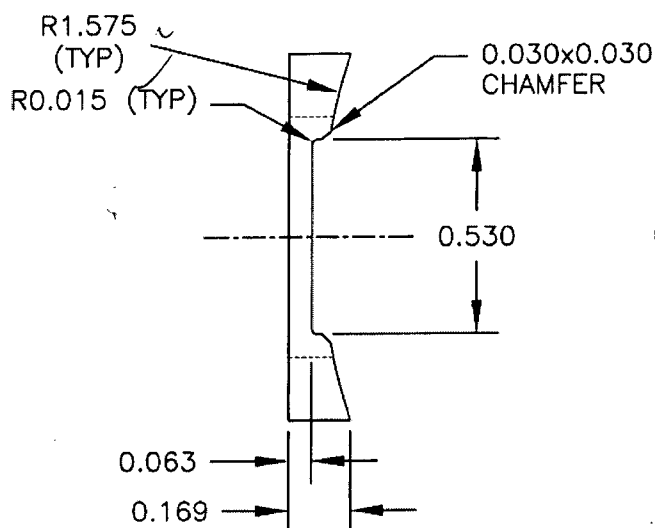
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

RELEASED
05.09.06**ISOMETRIC DETAIL****D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31933

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DART AEROSPACE LTD		Work Order:	31933
Description: Washer		Part Number:	D3457-1
Inspection Dwg:	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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[illegible]

Measured by:	MS / J.F.	Audited by:	SA	Prototype Approval:	
Date:	07/06/13	Date:	07/06/17	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	